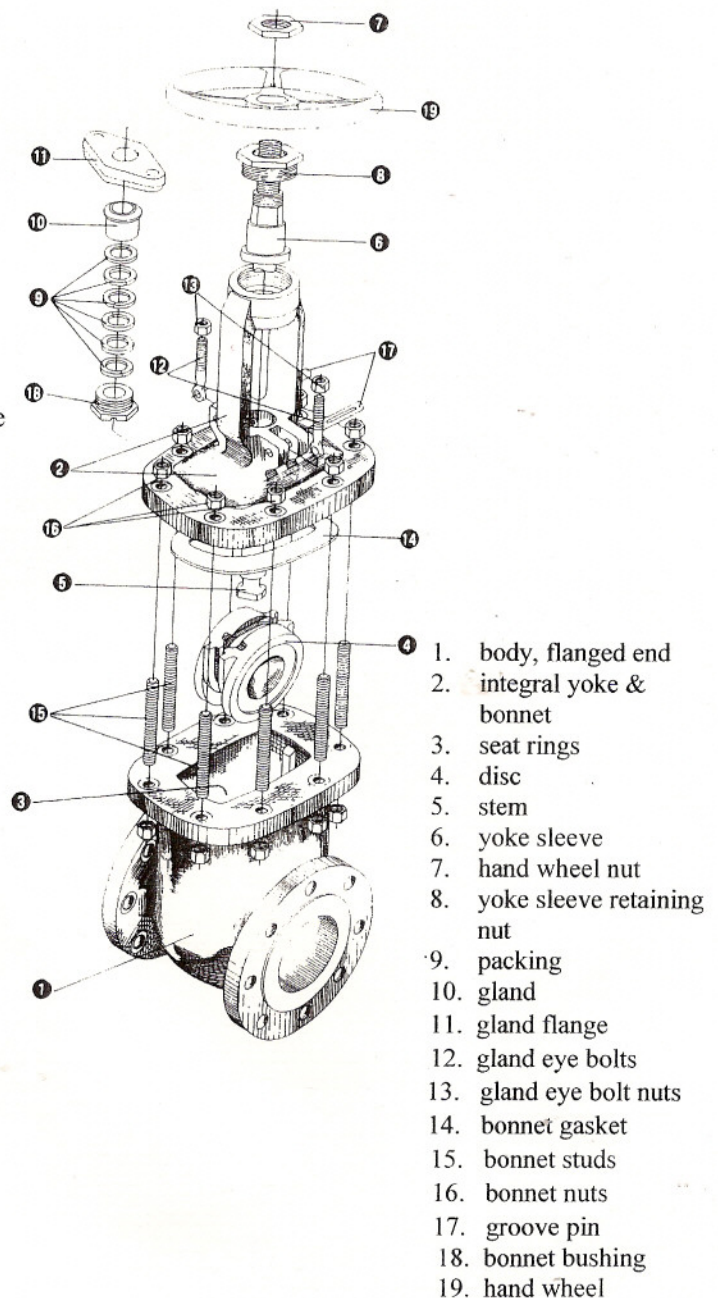


STANDARD REPAIR~GATE VALVE

THIS WORKSCOPE APPLIES TO BOLTED TYPE BONNET AND PRESSURE SEAL BONNET GATE VALVES

- Disassemble completely
 - Clean all component parts
 - Inspect all component parts for wear and defects
 - Non Destructive Examination-PT (Penetrant Testing) all seating surfaces i.e. seat ring faces, disc faces, bonnet and stem backseat areas
 - Grind/polish disc and seat surfaces. Seat contact proved by 360 degree blue in
 - Verify body/guide disc guide clearances
 - Verify stem straightness for TIR (true indicator reading) run out
 - Polish stem to necessary RMS finish
 - Clean all gasket surfaces
- PRESSURE SEAL VALVES**
- Hone bore to proper surface finish and record dimension for new pressure seal gasket (required when a valve is disassembled). Recondition pressure seal angle on valve bonnet
 - Re-assemble using premium quality packing and gasket materials
 - Hydrostatically test seat/s and shell at 1.5 times rated pressure
 - Paint, tag and ship to customer



NOTE: Minor welding is also covered in the standard repair. Manufacture of new components, heat treating requirements, or extensive welding will be considered additional work above and beyond the standard repair scope. A report noting these conditions will be submitted to the customer for approval prior to proceeding.